



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2652

Job Sheet 202013



Part No: D2652

Part Name: Bushing

Job Qty: 400 pcs



Part Weight: 0 lbs

Job Created: 10/17/19

Due Date: 11/8/19

Type: SOLD

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV A IPP Rev:B 02.06.13 Now machined in house. NG

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Hardinge - 1	400 pcs	11/8/19	11/8/19	0.50	14.72	Hardinge - 1	
110	QC 2	400 pcs	11/8/19	11/8/19	0.00	0.00	QC 2 - 1	BL 1910-21-
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	



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CANADA
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www.dartaerospace.com

Container No: S224620



Part: D2652

Job No: 202013

Serial No/Batch: S224620

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/21/19

DAS
65 19-10-21

9-89

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120 QC 8	400 pcs	11/8/19	0.00	0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
130 Packaging 3-1 - Stock - B4B	400 pcs	11/8/19	0.00	0.00		

19/10/22

PC 5009

140 QC 21 - SA	400 pcs	11/8/19	0.00	0.00	Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					QC 21 - SA - 21	
					QC 21 - SA - 70	0.05
					QC 21 - SA - 53	0.21
					Broussard	0.05

Part Op 100 - (Hardinge) 1-TURN AS PER FOLIO FA252 & DWG D2652
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

OCT 23 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.500	303 Round Bar 0.500"	22 ft (.055 ea)	100-Hardinge - 1	522 1908

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M303R0.500	22	38	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.600inches ± 0.010	0.610 0.590	0.600	
2	Bushing	0.060inches ± 0.005	0.065 0.055	0.060	
3	Bushing	0.305inches + 0.000 - 0.002	0.305 0.303	0.304	
4	Bushing	0.191inches + 0.005 - 0.001	0.196 0.190	0.192	
5	Bushing	0.500inches ± 0.010	0.510 0.490	0.495	
6	Bushing	0.030inches ± 0.010	0.040 0.020	0.035	
7	Bushing	20.000Degrees ± 0.010	20.010 19.990	20°	
8	Bushing	0.010inches + 0.010 - 0.000	0.020 0.010	0.010	

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS																																																																																	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																																																																																	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)																																																																																	
Description Work Order Deviation		Disposition																																																																																			
Root Cause <table border="1"><tr><td>Operator</td><td>☐</td></tr><tr><td>Manufacturing Process</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td></tr><tr><td>Handling/Preservation</td><td>☐</td></tr><tr><td>Material</td><td>☐</td></tr><tr><td>Product Improvement</td><td>☐</td></tr><tr><td>Process Improvement</td><td>☐</td></tr><tr><td>Human Factors</td><td>☐</td></tr></table>		Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"><tr><td>Pressure/Forced</td><td>☐</td><td>Contamination</td><td>☐</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr><tr><td>Bending</td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Tolerance</td><td>☐</td></tr><tr><td>Crushing</td><td>☐</td><td>BOM/Route</td><td>☐</td><td>Grain Direction</td><td>☐</td><td>Drawing</td><td>☐</td></tr><tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Finish</td><td>☐</td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td><td>Incomplete/Unclear Instructions</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr><tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Misread</td><td>☐</td></tr><tr><td>Mislabeled</td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Off-set/Set-up</td><td>☐</td><td></td><td></td></tr><tr><td colspan="2">Other/Details: _____</td><td colspan="6"></td></tr></table>				Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐			Other/Details: _____							
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